

86661

July-06-12 11:17:46 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/06/12 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 7/06/12 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: Date: 12-07-6 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

100		0.00	
100	HAAS CNC VERTICAL MACHINING #1		
HAAS 1	Memo	0.00	SL 12-08-28 (6)
HAAS CNC vertical machine #1	Program Batch No. <u>86661</u> Double check by: <u>H. a.</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets3-Machine Step No 3 per Folio FA051 and inspect		PD 12/08/26
110		0.00	
110	CONVENTIONAL MILLING MACHINE		SL 12-08-28
Mill Conv	Memo	0.00	
Conventional Milling Machine	Machine keyway as per dwg D2571 & D2572		
120		0.00	
120	QC2- Inspect parts off machine FAI/FAIB		SL 12-08-28
QC	Memo	0.00	
Quality Control			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86661

86661

Page 2

July-06-12 11:17:46 AM

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd Out 205
 Start Date: 7/06/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 14 2.89 F.K. 12/08/29 0.00				6	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6	76	12-8-29	
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 3:30 FINISH TIME: 4:00	0.00 0.00				6X	0	12/08/29	M-F

m121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86661

86661

Page 3

July-06-12 11:17:46 AM

Item ID: D2571 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, Fwd Out 205
 Start Date: 7/06/12 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						6v	4	44	n/08/30
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 441	0.00							
170						6		SL	12/8/30
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MF
12-08-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-06-12 11:17:46 AM

Page 1

Work Order ID: 86661

Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007 Saddle Billet		Manufactured	No			100	Each	33.0000	1	6	10	12/08/12	

Location

Loc Qty

Loc Code

MAT041

30

85432

30

MAT042

3

79875

1

85432

2

P

87630

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	86661
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.001	8.000		
F	0.490	0.510		0.498	.500	.499	.501		
G	0.257	0.262		0.258	.258	.258	.258		
H	0.375	0.380		0.378	.377	.377	.377		
I	0.490	0.510		0.498	.501	.502	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.563	.567	.569	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.127	.125	.124	.125		
Q	0.115	0.135		0.135	.135	.135	.135		
R	0.240	0.260		0.251	.251	.252	.251		
S	0.115	0.135		0.126	.126	.126	.125		
T	0.178	0.198		0.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	.240	.240	.240		
W	0.115	0.135		0.118	.121	.121	.122		
X	0.308	0.313		.310	.309	.318	.310		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		0.353	.357	.361	.360		
AA	0.470	0.530		0.500	.50	.50	.50		
AB	0.615	0.635		0.625	.625	.625	.625		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		0.247	.248	.250	.249		
AE	1.375	1.395		1.389	1.389	1.388	1.390		
AF	0.115	0.135		0.135	.135	.135	.135		
AG	0.240	0.280		0.240	.240	.260	.260		
AH	0.240	0.260		0.249	.249	.250	.250		
AI	2.000	2.020		2.004	2.004	2.004	2.004		
AJ	0.023	0.043		0.033	.033	.033	.033		
Accept/Reject								DA	

Measured by: PD	SL
Date: 12/08/26	12-08-28

Audited by: F.K.	11
Date: 12/08/29	2-89

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

1972

1973

DART AEROSPACE LTD	Work Order: 8661
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	3	4		
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.499	.500				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.500	.501				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.568	.568				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.252	.251				
S	0.115	0.135		.125	.125				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.240	.240				
W	0.115	0.135		.120	.120				
X	0.308	0.313		.310	.310				
Y	0.760	0.765		.762	.762				
Z	0.352	0.372		.361	.360				
AA	0.470	0.530		.50	.50				
AB	0.615	0.635		.626	.626				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.248	.248				
AE	1.375	1.395		1.388	1.388				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.250	.250				
AI	2.000	2.020		2.004	2.004				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: X
Date: 08-28

Audited by: F.H.
Date: 12/08/29

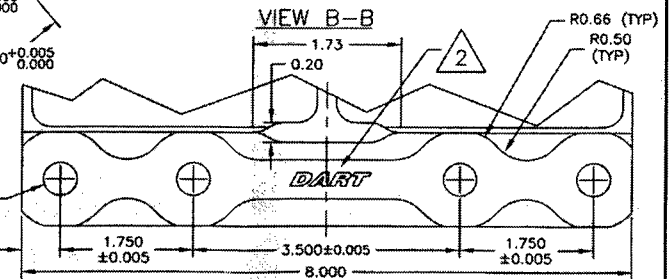
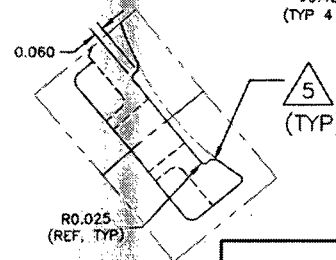
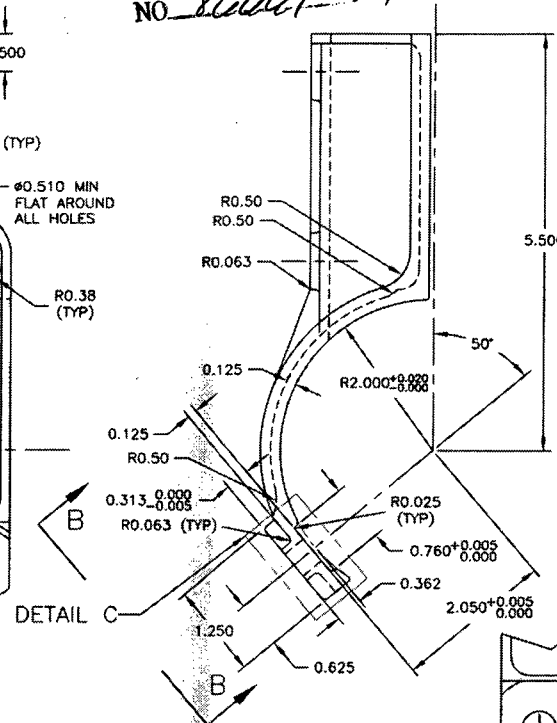
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

WITNESS MY HAND
WORK ORDER
NO. 86661

05.12.06

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALDINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- $\triangle E$



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN OS	DRAWN BY PH	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2571	REV. E SHEET 1 OF 1
DATE 05.07.13		TITLE OUTER FWD SADDLE	SCALE 2:1

